












Date: Friday, 5/25/2007 8:16:35 AM
 User: Kim Johnston

Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	WEARSHOE
Job Number:	32580	Part Number:	D265623
Estimate Number:	10615	Drawing Number:	D2656 REV D
P.O. Number:	N/A	Project Number:	N/A
This Issue:	5/25/2007	Drawing Revision:	D
Prsht Rev:	NC	Material:	N/A
First Issue:	N/A	Due Date:	6/10/2007
Previous Run:	30944	Qty:	26
Written By:		Um:	25
Checked & Approved By:	07.05.28		
Comment:	Est: D 02.10.25 Re-format KJ		
Additional Product			
Job Number: 			
Seq. #	Machine Or Operation:	Description:	
1.0	M1010S20GA	1010/1025/A21/6aA SHEET	
			
Comment: Qty.: 1.4800 sf(s)/Unit Total: 36.9994 sf(s)			
1018 20 GA .040" THK			
Batch: M104752			
SAD 07/06/19			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET			
1-Cut as per Dwg D2656			
Dwg Rev: 2			
Prog Rev: 2			
2-Deburr if necessary			
SAD 07/06/19			
3.0	QC2	INSPECT PARTS:AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
SAD 07/06/19			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
En 07/06/19			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE			
1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326			
2-Form joggle as per Dwg D2656 using Jig DT8158			
3-Identify as D2656-23			
SAD 07/07/18			
SAD 07/07/18			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:16:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32580

Part Number: D265623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



contap

Comment: INSPECT WORK TO CURRENT STEP

En 07/07/18 (26)

7.0

POWDER COATING

POWDER COATING



M1104846



(26x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/07/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m 07/07/21



(26)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(26x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-18

m-l 07/07/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



07/07/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

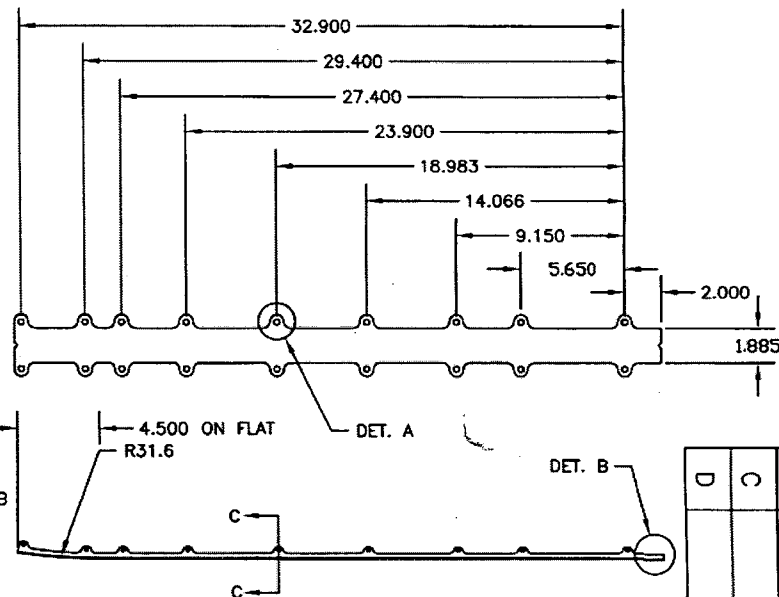
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

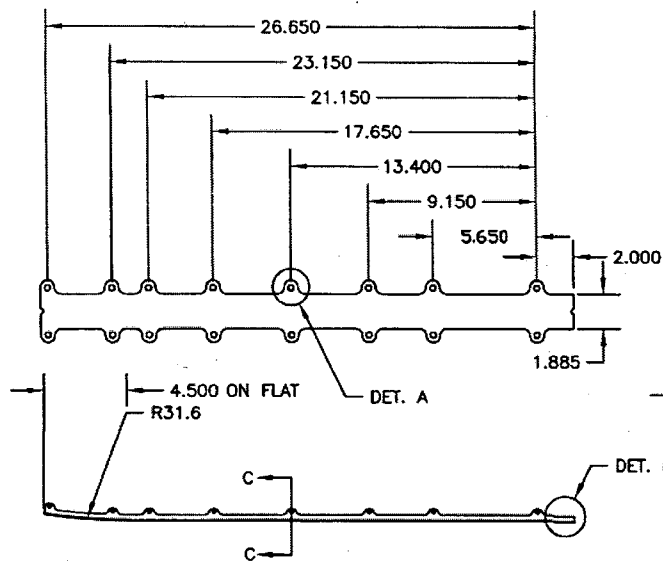


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	PORT HADLOCK, WA
DATE	05.08.17	TITLE	WEARSHOE	REV. D	SHEET 1 OF 4
				SCALE	1:10
A		97:03:25	NEW ISSUE		
B		97:06:02	CHANGED TABS		
C		97:06:26	R31.6 WAS R19.5		
D		05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

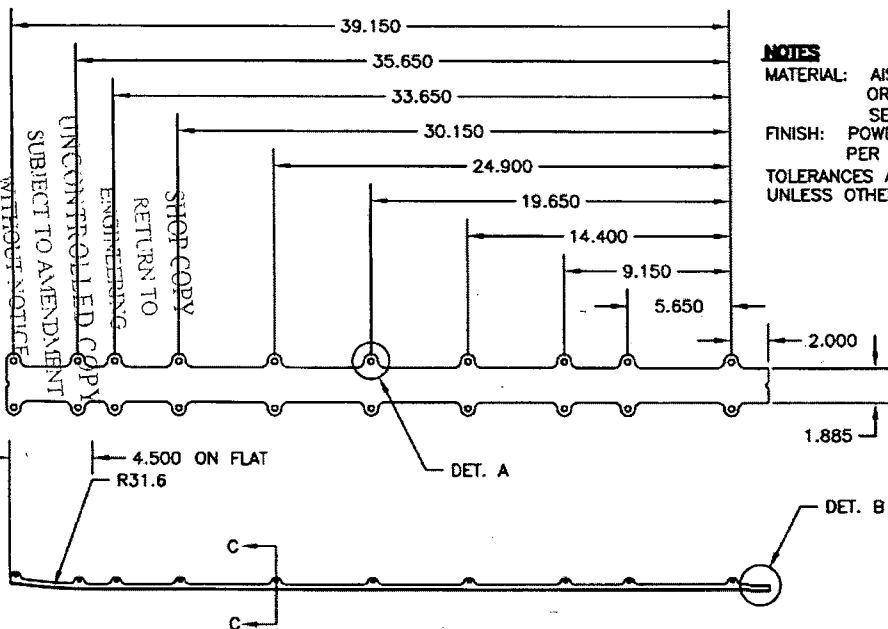
D2656-13



D2656-11



D2656-15



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.02

WORK ORDER
NO. 32580

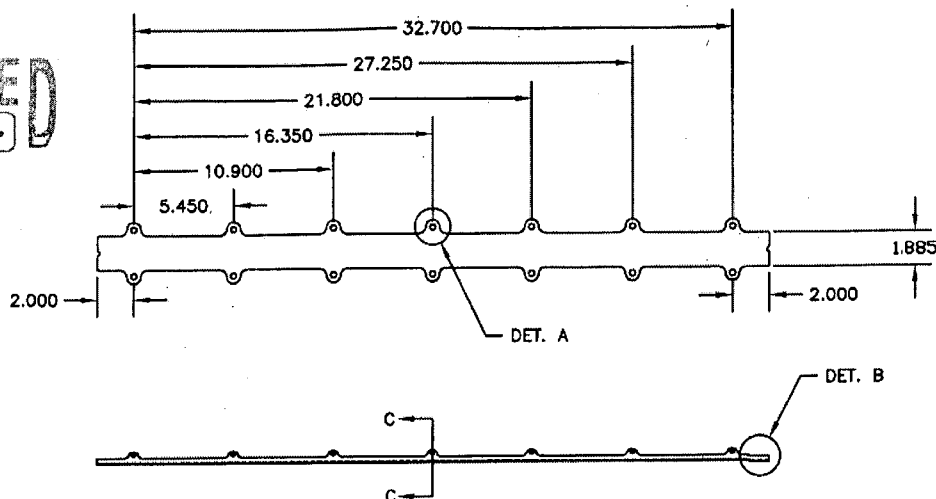
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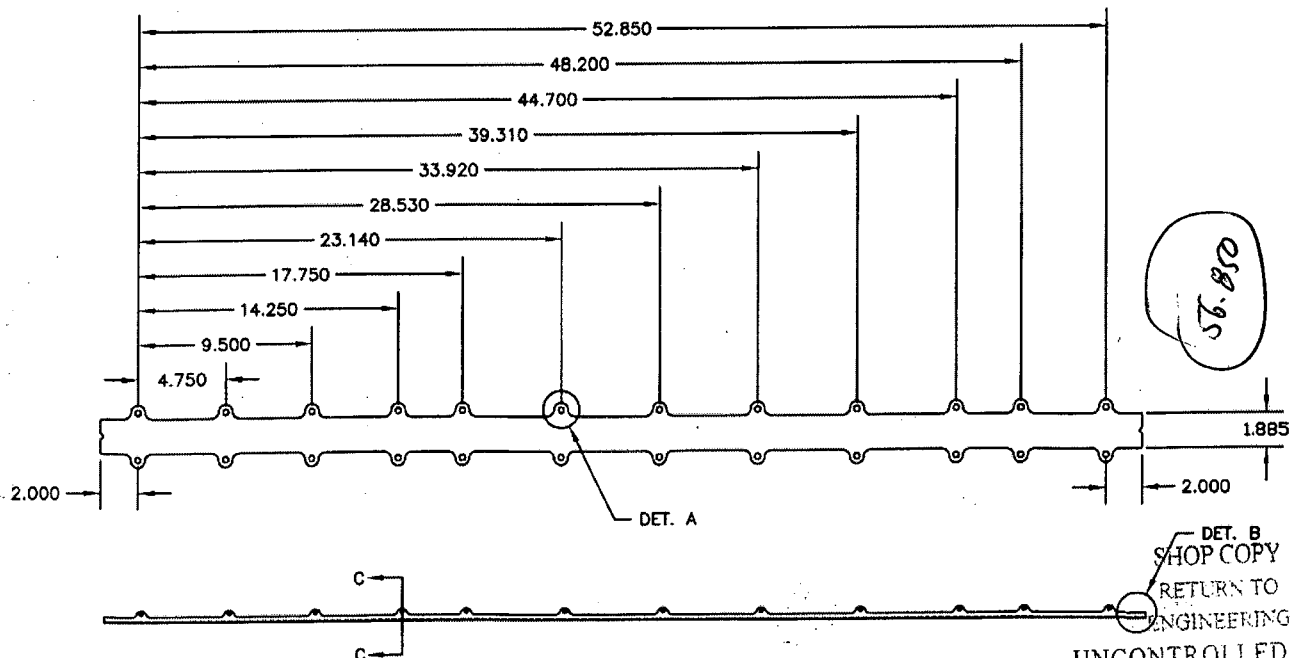
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED
DS-09-06 *[Signature]*

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 32580

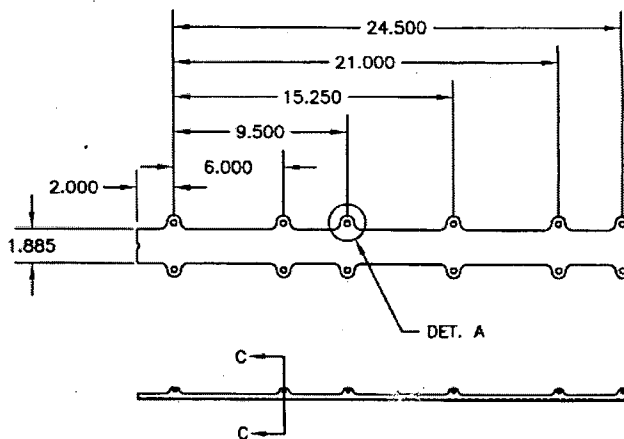
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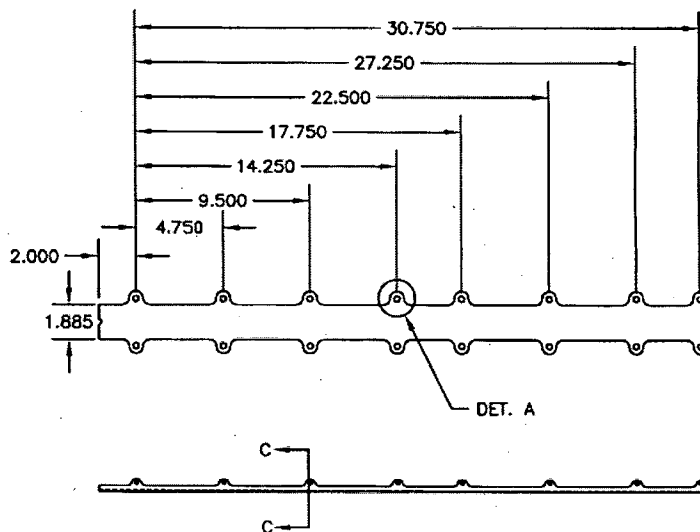


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DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 3 OF 4
				SCALE 1:10

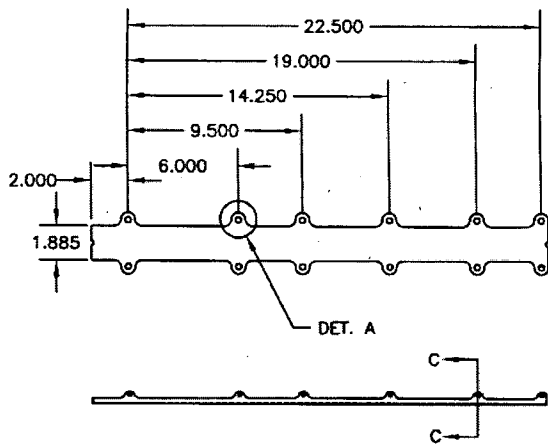
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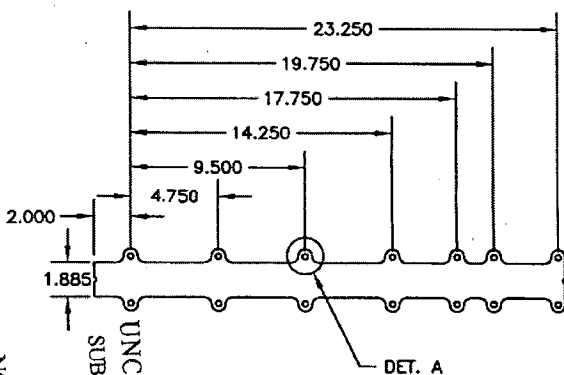
D2656-37



D2656-31



D2656-35



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05-01-06

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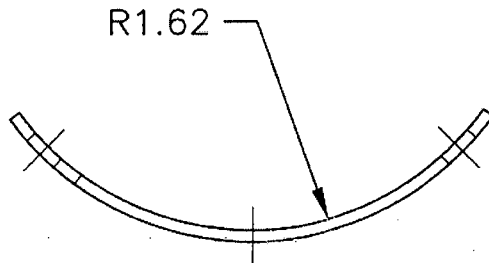
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SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

WORK ORDER
NO. 32580



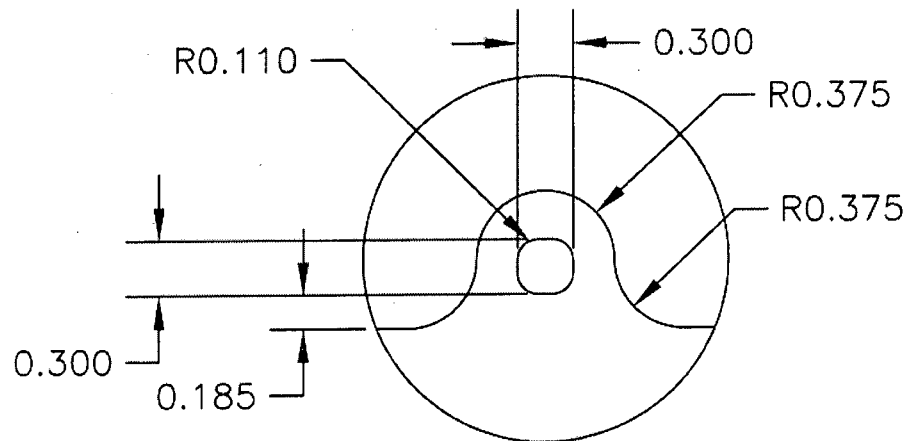
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

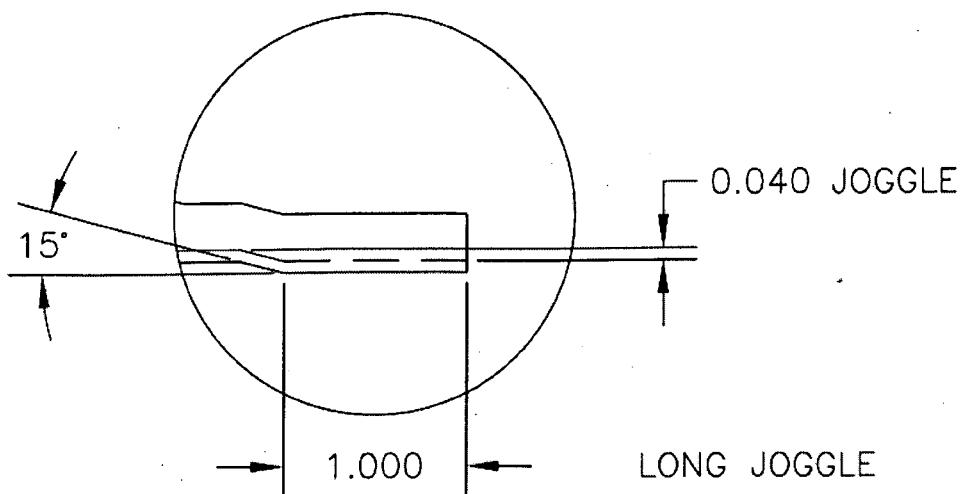


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05.09.06 *[Signature]*

DETAIL A



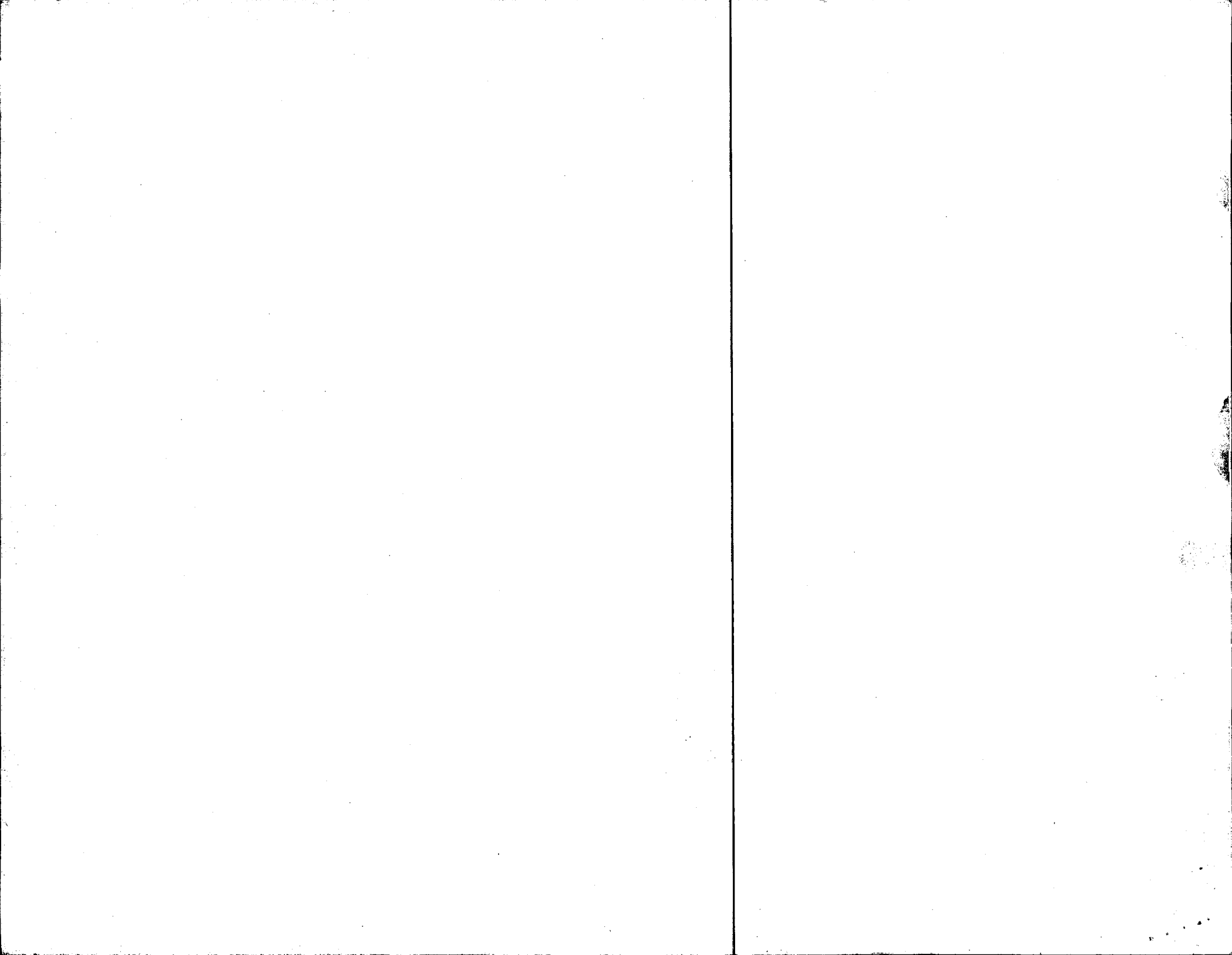
DETAIL B



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DART AEROSPACE LTD		Work Order: 32580
Description: WEARSHOE		Part Number: D265025
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 52.850	+/- 0.010	52.875	✓		M-T	
B 48.200	+/- 0.010	48.200	✓		M-T	
C 44.700	+/- 0.010	44.700	✓		M-T	
D 39.310	+/- 0.010	39.310	✓		M-T	
E 33.920	+/- 0.010	33.920	✓		M-T	
F 28.530	+/- 0.010	28.530	✓		M-T	
G 23.140	+/- 0.010	23.140	✓		M-T	
H 17.750	+/- 0.010	17.750	✓		M-T	
I 14.250	+/- 0.010	14.250	✓		M-T	
J 9.500	+/- 0.010	9.500	✓		M-T	
K 4.750	+/- 0.010	4.750	✓		Vern	
L 2.000	+/- 0.010	2.000	✓		Vern	
M 1.885	+/- 0.010	1.891	✓		Vern	
N 0.300	+/- 0.010	0.302	✓		Vern	
O 0.300	+/- 0.010	0.299	✓		Vern	
P 0.040	+/- 0.010	0.035	✓		Vern	
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: En	Prototype Approval:	N/A
Date: 07/06/19	Date: 07/06/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

